

Date: Tuesday, 3/28/2006 1:10:09 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP
Job Number	: 26089		
Estimate Number	: 12320		
P.O. Number	: N/A	Part Number	: D350636101
This Issue	: 3/28/2006 S.O. No. : N/A	Drawing Number	: D3487 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 26089	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/4/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	50 Um: Each
Comment	: Est Rev:A New Issue 06-03-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD350-636-101 CHG001

06/03/08

DH

(50)

2.0	PG	PURCHASING
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Comment: Issue P/O: 7166
 E-mail or Ship DXF file to vendor
 Laser cut flat pattern as per Dwg D3487
 Possible supplier: GFI
 Material release note is required.

C 206/03/28

(50)

3.0	D34871F	STEP FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 STEP FLAT PATTERN

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

50pc

AP 06/04/12

5.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

AP 06/04/12
 AS QSI AT

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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if Neccesary

SAD 06:04:19 (43)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3487

N/A

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

060420

50

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:04:23

PTO

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/04

(43)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3487 and QSI 005 4.4

DL 06/05/04

(43)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 05 06

(43)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pick packing Kit.

1 D3487-1 Toe Cap Batch: B26089

2-Identify and pack for shipping as per PPP D350-636-101





Location: FG 13

DNAF

06/5/8 (43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-27	9	7 pcs found in bottom of chlorine and/or acid tanks		scrap parts - advise employee to count parts and to make sure all are out of tanks!	U 06-04-27	 06-04-27	 05-11-27	 06-04-27

NOTE: Date & initial all entries

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Drawing Name: STEP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

PPP Rev:

DRAFT

204/5/8

(43)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

N/A

204/5/8

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP

06/25/10

Job Completion



U 06-05-09

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>1</u>	OUR JOB NO	<u>J0140503</u>	SHIPPING MEMO	<u>0334704</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>50 PCS</u>	<u>PO00000766</u>	<u>D34871F</u>	<u>A</u>	<u>CLAMP</u>	<u>A</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 6061-T6</u>		<u>SAMUEL / CORUS ALUMINUM</u>		<u>7114901 ATT'D</u>		
PROCESS		PROCESSOR		RELEASE NOTE #		
1						
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 10 APRIL 2006

G.F.I. Q.C. REP. Belton Skerid



LES MÉTAUX SPÉCIALISÉS **SAMUEL**

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 21 MARS 2006

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0060139
Customer's order #:

de commande SSMQ: 852257
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	1	100" X 48" X 144"	6061 T6	AMS-QQ-A-250/11	7114901

Bien à vous,
Yours truly,

José Raymond

Commis à l'administration.
Administration Clerk.



DOC : V/0080147319

DATE : 2005-03-11

PROD. REF. : 0000169840

NR : 54018/06

PAGE : 1 / 1

INSPECTION CERTIFICATE



CUSTOMER : CORUS ALUMINIUM ROLLED PRODUCTS US

475 N. MARTINGALE ROAD, SUITE 400
SCHAUMBURG 60173 USA

Corus Aluminium N.V.

A. Stocklaan 87, 2570 Duffel - Belgium

Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

 DESCRIPTION : ALU SHEETS (ETENC) AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
 DIMENSIONS : 144" X 48" X .11"
 ARTICLE NO. :

 YOUR ORDER NUMBER : PO3062 (Samuel's PO# A15863)
 OUR ORDER NUMBER : 54018/06
 DOCUMENT NUMBER : V/0080147319
COIL
NUMBERCAST
NUMBER

CHEMICAL COMPOSITION (%)

COIL NUMBER	CAST NUMBER	SI	FE	CU	MN	MG	CR	TI	ZN
001	7114901	MIN 0,40	0,7	MIN 0,15	0,15	MIN 0,8	MIN 0,04	0,15	0,25
		MAX 0,8		MAX 0,40		MAX 1,2	MAX 0,35		
		0,68		0,4		0,25	0,09		

OTHERS : EACH
TOTALMIN
MIN 0,05 MAX
0,15 MAXTEST-
NUMBER

MECHANICAL PROPERTIES

 1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI
 /A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

TEST- NUMBER	MIN MAX	RM KSI	RP02 KSI	A %
001	/A	42	35	10
001	/M	48	40	17
001	/V	48	40	15
				14

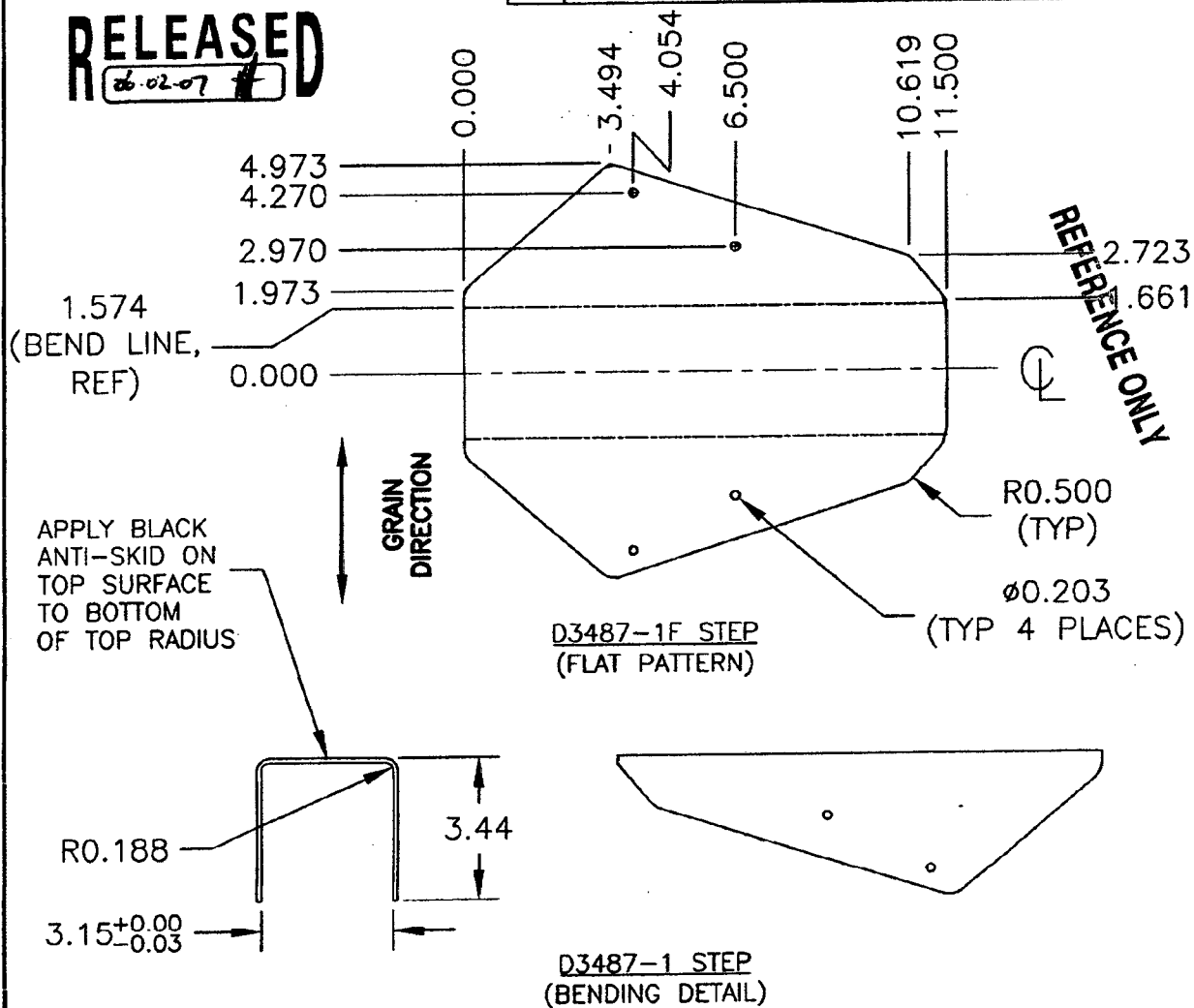
HEAD OF LABORATORY,
XAVIER SCHELTJENS

Corus Aluminium Rolled Products - Corus Aluminium Extrusions

D399339
340
341

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3487	REV. A SHEET 1 OF 1
DATE 06.01.16		TITLE STEP	SCALE 1:4
A	06.01.16	NEW ISSUE	

RELEASED
06-02-07**D3487-1 STEP**

- 1) MATERIAL: ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK (REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

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